

Ship July 6th

Dart Aerospace Ltd.

Date: Tuesday, 6/26/2007 3:06:41 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 33133	
Estimate Number : 12625	
P.O. Number : N/A	Part Number : D2127251903
This Issue : 6/26/2007 S.O. No. : N/A	Drawing Number : D212-725-1 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30164	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 7/3/2007 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A New Issue 07-01-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0625W035	304 RD Tube .625 x .035W
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Comment: Qty.: 0.5775 f(s)/Unit Total : 2.3100 f(s)

304 RD Tube .625 x .035W

Batch: M 103240

FF 07-07-04

4

2.0	AN81810J	nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

nut

Batch: M 102850

FF 07-07-04

4

3.0	MS2081910J	sleeve
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

sleeve

Batch: M 102850

FF 07-07-04

4

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form tube as per Dwg D212-725-1& Template DT8906.

2- Flare tube @ 37 deg ,Install sleeve & Nuts as per Dwg D212-725-1.

FF 07-07-04

4

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

FF 07/07/07 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 33133

Part Number: D2127251903

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SE 182

7/1/5 59

4x h

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

4
7/27/07/06

Job Completion



u 8/8/06

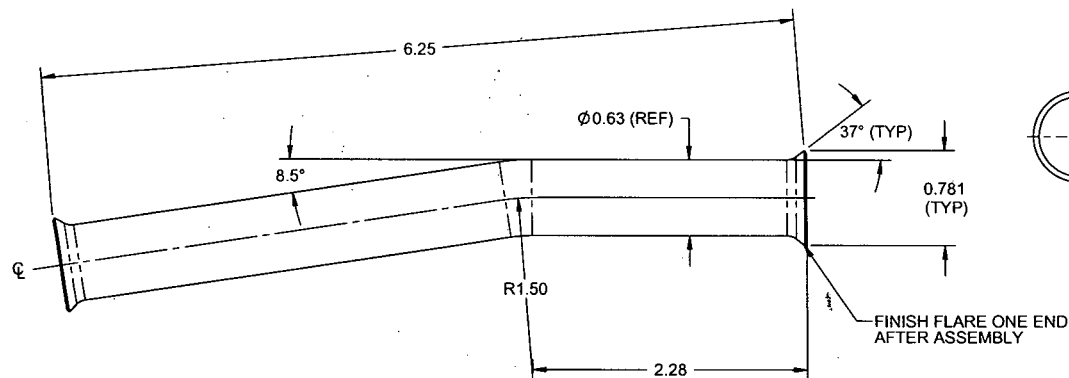
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

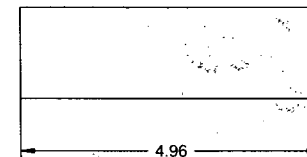
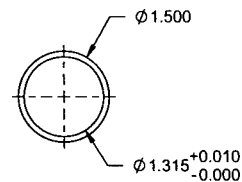
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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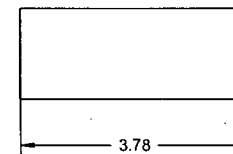
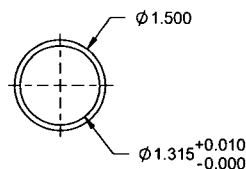
NOTE: Date & initial all entries



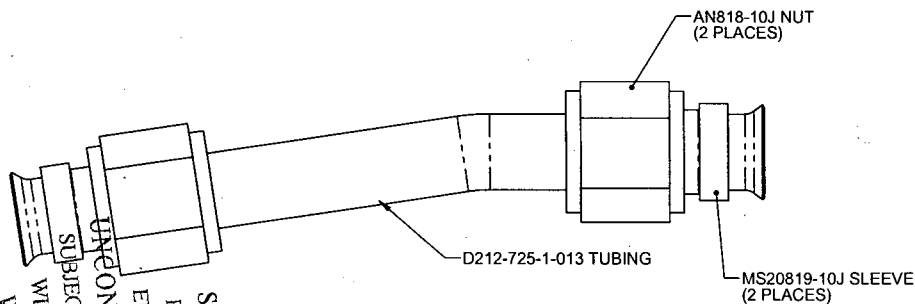
D212-725-1-013 TUBING
MANUFACTURE PER TEMPLATE DT8906



D212-725-1-025 SPACER
SCALE 1:2



D212-725-1-027 SPACER
SCALE 1:2



D212-725-1-903 TUBE ASSEMBLY

D212-725-1-025/-027 NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM (REF. DART SPEC. M6061TX.XXXW.XXX OR M6061T6R)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

D212-725-1-013 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBING 0.625 O.D. x 0.035 WALL (REF. DART SPEC. M304TR0.625W0.035)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 6 OF 37
DATE 06.12.08		TITLE 212S DETAIL PARTS	SCALE 1:1
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 WORK ORDER
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 ENGINEERING
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